

Work Order ID 55713

January 28, 2010 11:05:17 AM



Page 1

Item ID: D3954-3

Accept



Setup Start



Revision ID:

Item Name: GWT Knob

Stop



Start Date: 1/29/2010 Start Qty: 16.00



Cust Item ID:

POSITIVE
RECALL

Required Date: 2/15/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-1-28 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3954

B

100



Waterjet

FLOW CNC Waterjet

100 .375x3.00

Memo

1-Cut as per Dwg D3854

Dwg Rev: R

Prog Rev: R

2-Deburr if necessary

HB 10-2-2

JB 102/04 60

110

QC2- Inspect parts off machine FAI/FAIB



QC

Quality Control

0.00

0.00

HB 10-2-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



Required Date: 2/15/2010 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Memo

Set Up/
Run Hours

0.00

=> S_1010208

Draw
Number

0.00

0.00

Draw
Rev.

0.00

0.00

Plan
Code

0.00

0.00

Accept
Qty

0.00

0.00

Reject
Qty

0.00

0.00

Reject
Number

0.00

0.00

Insp.
Stamp

130



Mill Conv

Conventional Milling Machine

Memo

1-OPEN TO TAP DRILL SIZE

2-TAP AS PER DWG D3954

0.00

0.00

AF 10/02/08

(20) ✓

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> S_10102108

counts
(20)

W/O:		WORK ORDER CHANGES					
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Item Name: GWT Knob

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Cust Item ID:

Required Date: 2/15/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

 SprayPaint
Spray Painting

 paper
crt

M11354U

Memo

 1- MASK THREADS PRIOR TO PAINTING AS PER DWG
 2- SPRAY PAINT YELLOW AS PER DWG
 A/R BATCH:

0.00

5

 Powder-coat yellow
 Start 3:15pm
 Finish 3:20pm
 OverTemp. 3:45pm

20.0

160

 QC

Quality Control

QC1- Inspect Spray Paint

FINISH

FINISH

0.00

0.00

BF 10-02-10

(20) ✓

170

 Packaging

Packaging

Identify as per dwg & Stock Location: 102

0.00

Memo

0.00

10/2/11 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Qty 1 taken for HAI 2010. SRO 10.02.09.					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Cust Item ID:

Required Date: 2/15/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/03/11 JG

Memo

0.00

1/29/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55713



Parent Item: D3954-3



Parent Item Name: GWT Knob

Start Date: 1/29/2010

Required Date: 2/15/2010

Comments:

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010B0.375X03.500		Purchased	No			100	f	13.9600	0.4679	3.		10-2-2

1010-1025 Steel Bar .375 x 3.500



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	13.96
102179	2.46
110740	11.5

(60)

110740

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DART AEROSPACE LTD	Work Order:	55713
Description: GWT Knob	Part Number:	D3954-3
Inspection Dwg: D3954 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-2-2	Date:	10/02/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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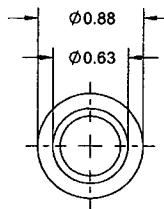
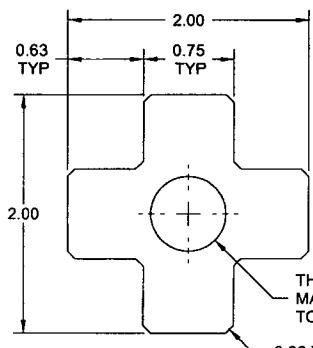
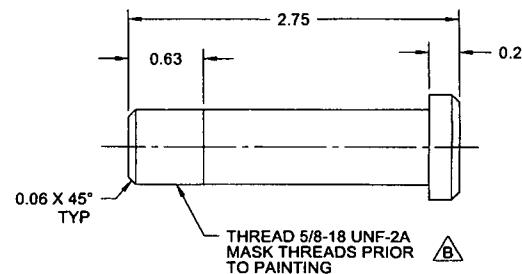
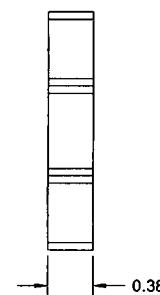


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8 7 6 5 4 3 2 1

**D3954-1 GWT PIN****D3954-3 GWT KNOB**

NOTES:
1) MATERIAL -1: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

-3: AISI 1010-1025 MILD STEEL SHEET
PER DART SPEC MS1010-S

OR: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

ALTERNATE MATERIAL:

-1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND 60103B PER DART QSI 005 4.2
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

Yellow POWDER COAT
M10/10/08

RELEASED
2009-10-19

M

DESIGN	AJS/DSTOW	DART AEROSPACE LTD
DRAWN	AJS	HAWKSLEY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3954
APPROVED	N/A	REV. B
DE APPR.	N/A	SHEET 2 OF 3
DATE	09.10.15	TITLE
		SCALE
		MISC MACHINED PARTS GWT KIT
		NTS

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